



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

2006493

646.4003
Job Sheet 186125



Part No: 646.4003

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 11/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 16 2018
110	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-1		NOV 16 2018
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC4		NOV 19 2018
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		NOV 19 2018
135	DC	1 pcs	11/30/18	11/30/18	0.00	0.00	DC		NOV 19 2018
140	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		NOV 19 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4003 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4003

21
9-89

NOV 19 2018

Fy102



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S128594



Part: 646.4003

Job No: 186125

Serial No/Batch: S128594

Revision: C1

Inspector:

Exp Date:

Instructions: FAA STC SR02180LA 08/12/16, EASA STC SH09-10 Issue 1, BRAZIL

NOV 10 1968
NOV 10 1968
NOV 10 1968
NOV 10 1968

#1 JOB 186/25

006493

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121187
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121188
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5119525
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119441
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125414
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5117183
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119224
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5056453
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5081639
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5038795
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5159862
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5039275
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5038803
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5052883
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5083586x2 5065272x2
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5076145
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5126060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5097197
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118480
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5098034
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-4A	Bolt	6 Ea (6 ea)	90-Start up Operation	5060002
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5104032
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5107789
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5153848
MS21042-08	Use Ms21042L08	2 Ea (2 ea)	90-Start up Operation	5100404
MS21042-3	Nut	804 2 Ea (2 ea)	90-Start up Operation	5108577
MS21042L3	Nut	53 Ea (53 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5109736
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5006971
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5049833
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5037684
NAS1149F0332P	Washer	120 Ea (120 ea)	90-Start up Operation	5109991
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5107796

Exp. 10/19
Exp 4/19

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	224	0
	600.0990	1	11	0
	600.0991	1	11	0
	600.1012	1	24	0
	600.1013	5	67	0
	646.2910	1	24	0
	646.3001	1	13	0
	646.3110	1	11	0
	646.3301	1	11	0
	646.3510	1	16	0
	646.3511	1	21	0
	646.3610	1	21	0
	646.3711	1	31	0
	646.3712	1	19	0
	646.3716	1	37	0
	646.3718	2	38	0
	646.3811	1	28	0
	646.3910	4	55	0
	646.3911	1	20	0
	646.3912	4	53	0
	646.3913	1	36	0
	646.9410	1	98	0
	647.0112	2	82	0
	647.7703	2	10	0
	650.9201	2	31	0
	AN3-11A	10	145	0
	AN3-12A	2	90	0
	AN3-13A	1	96	0
	AN3-4A	6	344	0
	AN3-5A	2	314	0
	AN3-6A	2	178	0
	AN316C4R	2	33	0
	AN44-5A	2	27	0
	AN4C7A	2	139	0
	AN665-34R	2	25	0
	MS20426AD5-7	2	988	0
	MS21042-08	2	1	0
	MS21042-3 <i>L3</i>	2	214	0
	MS21042L3 <i>S</i>	<i>SS</i> 53	2,015	0
	MS21042L4	2	2,292	0
	MS24693-C278	5	139	0
	MS24694-S51	5	295	0
	MS24694-S54	2	406	0
	MS24694-S55	3	98	0
	MS27039-08-13	2	578	0
	MS27039-1-12	6	246	0
	MS27039-1-16	24	573	0
	MS27039-1-19	22	329	0
	MS27039-1-20	2	99	0
	MS27039-1-21	4	110	0
	NAS1149F0332P	120	1,801	0
	NAS1149F0432P	4	706	0
	NAS1149FN832P	4	2,479	0

Part Specifications

Specifications could not be found.

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
2. INSTALL F/N 14 WITH F/N 52 & 53.
3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMaster-CARR P/N 75935A651.
4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.
5. REUSE FASTENERS FROM F/N 1.
6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.
8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.
9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

0.5304

	5	5	5	78	601.3875	SCREW	MAGNIBOND	△		
1	1	1	1	77	646.9410	SHIM		△		
	4	4	76	601.2764	WASHER		NAS1149P083P			
	2	2	75	601.2973	LOCKNUT		MS21042-08			
	2	2	74	601.2988	SCREW		MS27039-0813			
	2	2	73	601.2943	LOCKNUT		MS21042-3			
	2	2	72	601.3128	NUT		AN316CAR			
	2	2	71	601.3209	LOCKNUT		MS21042A			
	4	4	70	601.2638	WASHER		NAS1149P0433P			
	2	2	69	601.2669	BOLT		AN4CTA			
	2	2	68	601.3119	CLEVIS		AN665-34R			
	2	2	67	601.3121	EYE BOLT		A144-5A			
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT			△		
		2	64	601.3151	WASHER		NAS1149P0363P			
			63	601.2911	SCREW		MS24694553			
	24	24	62	601.2637	SCREW		MS27039-1-16			
2	2	2	61	601.2763	BOLT		AN3-12A			
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT		PR1425 CLASS B			
	1	1	53	600.0991	MAGNIBOND 639B PART B		△			
	1	1	52	600.0990	MAGNIBOND 639B PART A		△			
6	10	10	51	601.2826	BOLT		AN3-11A			
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW		MS27039-1-18			
	2	2	48	601.1365	SCREW		MS27039-1-10			
	2	2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
	1	1	45	646.3717	DOUBLER					
	22	22	44	601.1946	SCREW		MS27039-1-19			
	2	2	43	601.1952	SCREW		MS27039-1-20			
	4	4	42	601.1956	SCREW		MS27039-1-21			
400b	400S	400A	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REFERENCE ONLY

REVISIONS			
RHV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED EGN 02319, 02315, 02719 & 02765	02/08/2010	P. BRAVO
B	INCORPORATED EGN 03046, 03079 & 04731	11/04/2014	P. BRAVO
C	INCORPORATED EGN 05098	01/09/2015	P. BRAVO

			2		2	41	601.2829	SCREW	MS24694554	
			2		2	40	601.2831	RIVET	MS20476ADS-7	
			1		1	39	646.3716	GAUGE BRACKET		
			6		6	38	601.1953	SCREW	MS27039-1-12	
		2			2	37	646.3715	STRUT DOUBLER		
		2			2	36	601.2824	BOLT	AN3-5A	
12		36			36	35	601.2277	RIVET	CCR2448F-3-02	
		18			18	34	600.0795	NUT/PLATE	MS201047-3	
3		3			3	33	601.2565	RIVET	MS20476ADS-7	
1		1			1	32	646.3813	STRUT BRACKET		
4		4			4	31	601.2822	BOLT	AN3-3A	
2		2			2	30	646.3812	GUSSET BRACKET		
8		8			8	29	601.2564	RIVET	MS20476ADS-6	
1		1			1	28	646.3714	GUSSET		
		1		1	1	27	646.3610	FILLER		
		3		3	3	26	601.2830	SCREW	MS24694555	
		2		2	2	25	601.2825	BOLT	AN3-6A	
		1		1	1	24	646.3811	RADIUS BLOCK		
		1		1	1	23	646.3712	CLIP		
		1		1	1	22	646.3711	CLIP		
					8	21	601.2832	RIVET	MS20476ADS-8.5	
14		14			14	20	601.2020	RIVET	CR3213-5-3	
4		6	4	6	10	19	601.2823	BOLT	AN3-4A	
		1		1	1	18	601.2827	BOLT	AN3-13A	
		5		5	5	17	601.2912	SCREW	MS24694551	
		1		1	1	16	646.3713	GUSSET		
		1		1	1	15	646.3210	SUPPORT		
				1	1	14	646.3710	DOUBLER		
				1	1	13	646.3110	CHANNEL		
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS1210421-3	
16	32	18	120	16	144	11	601.1607	WASHER	NA511491G32P	
					1	10	646.3410	LH WIPER DEFLECTOR		
						9	646.3411	RH WIPER DEFLECTOR		
				2	2	8	647.7703	STRUT ASSY		
				2	2	7	647.0112	STRUT BRACKET		
		1		1	1	6	646.3511	STRUT		
		1		1	1	5	646.3510	STRUT		
2		2			2	4	646.3810	BRACKET		
				1	1	3	646.2910	DEFLECTOR		
		1		1	1	2	646.3001	LOWER CUTTER ASSY		
				1	1	1	646.3301	UPPER CUTTER ASSY		
X							646.4006	LOWER CUTTER TIED PROVISIONS		
	X						646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X					646.4004	FIXED PROVISIONS KIT		
			X				646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS		
				X			646.4002	AS350 WIPER DEFLECTOR KIT		
					X		646.4001	AS350 CABLE CUTTERS KIT		
4005	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY	PARTS LIST				
NEXT ASSY (S)	ORIGINAL DATE MFG DATE 08-27-06 DRAWN BY JCYCER E. HUFF P. BRAVO DRAWING & PERSONAL P. BRAVO 08-27-06 CHECKED BY:	 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300 AEROSPACE AERIAL INDUSTRIES, INC DBA DART AEROSPACE			
AS350 CABLE CUTTERS KIT					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS 1/16 & 1/8 .010 3/16 & 1/4 .005 5/16 & 3/8 .005	SEE B B	CAB CO 07/MZ6 SCALF, NONF	DWS. NO. 646.4000 SHEET 1 OF 1	REV C

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